

5/06

DART AEROSPACE LTD.	Work Order:	22183
Description: 206/OH-58 Saddle, inboard, Right Side	Part Number:	D2933-2
Drawing: D2933 Rev B	Qty:	4

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Issue Work Order <i>Dwg. not required RF 02/09/16</i>	<i>PA</i>	05.01.14	4
2	STORES	Issue material from stock: 7075-T7351 QQ-A-250/12B ²⁰⁹⁸¹ Cut Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length ^{B20219} (D6101-001) RF 02/09/16 Batch No: <u>B20570</u>	<i>EC</i>	05.02.21	4
3	HAAS	Program batch number.	<i>EC</i>	05.02.21	4
4	QC	Inspect part number and batch number are programmed correctly.	<i>EC</i>	05.02.21	4
5	HAAS	Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet	<i>EC</i>	05.02.21	4
6	HAAS	Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet	<i>EC</i>	05.02.21	4
7	HAAS	Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet	<i>EC</i>	05.02.21	4
8	LAGUN	Machine Keyway and inspect per dwg D2933 & attached dimension sheet	<i>EC</i>	05.02.21	4
9	METAL	Deburr	<i>EC</i>	05.02.21	4
10	HAAS	Inspect Level 1	<i>EC</i>	05.02.22	4
11	QC	Inspect Level 8	<i>ML</i>	05.02.23	4
12	METAL	Acid etch and Alodine as per QSI 005 4.1	<i>ML</i>	05.03.02	4
13	FINISHING	Powder Coat Gloss White (4.3.5.1) per Dart QSI 005 4.3	<i>ML</i>	05.03.03	4
14	QC	Inspect Level 3	<i>CP</i>	05/03/07	4
15	STORES	Pack in foam, identify and stock.	<i>CP</i>	05/03/07	4
16	EXPEDITING	Close Work Order Job Cost / Part <u>106.56</u> <u>545</u> <u>05/03/08</u> <u>(4)</u> <u>79.34</u>	<i>PA</i>	05.03.09	4

Rev	Date	Change	Revised By	Approved
A	00.05.23	New Issue	EC	
B	00.06.26	New DWG rev (mpp 2069)	EC	

RELEASED

EC 00-06-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	22183
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.124	0.124	0.125	0.126		
B	0.100	0.140		0.126	0.124	0.126	0.127		
C	0.100	0.140		0.121	0.120	0.121	0.119		
D	0.210	0.230		0.225	0.224	0.224	0.225		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.501	2.501	2.501	2.501		
H	0.510	0.515		0.514	0.512	0.513	0.513		
I	1.572	1.582		1.580	1.578	1.579	1.579		
J	2.495	2.505		2.501	2.500	2.501	2.499		
K	0.257	0.262	DT8683	✓	✓	✓	✓		
L	0.312	0.317	DT8686	✓	✓	✓	✓		
M	0.235	0.240		0.238	0.237	0.237	0.237		
N	0.100	0.140		0.125	0.125	0.124	0.124		
O	0.540	0.560		0.542	0.542	0.541	0.543		
P	0.490	0.510		0.494	0.495	0.495	0.494		
Q	3.715	3.725		3.720	3.717	3.720	3.720		
R	2.470	2.510		2.500	2.500	2.501	2.499		
S	0.240	0.270		0.258	0.260	0.260	0.260		
T	0.100	0.180		0.147	0.145	0.147	0.150		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.368	1.368	1.368	1.367		
W	0.316	0.321	DT8690	✓	✓	✓	✓		
X	1.125	1.145		1.125	1.130	1.131	1.129		
Y	1.565	1.585	DT8695 A/B	✓	✓	✓	✓		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>EL</i>
Date:	05.02.21

Audited by:	<i>gmc</i>
Date:	05/02/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF <i>RF</i>	<i>[Signature]</i>

RELEASED
03.06.18 *RF*

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 12, 2005
01:18 pm

Work Order No : 0022183
Project Name : D2933-2
Project For : WK506
Work Order Type : Main
Main WO Number :
House Part Number : D2933-2
Description : 206 Saddle Right
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 01-12-05
Est Finish Date : 02-05-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00